

Work Order ID 77289***77289***

Page 1

Item ID: D206-642-541

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 01/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJDate: 11/12/01

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3274

D

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-541 CHG003

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Approvals:

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Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

K 12-01-13

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

BB 12/01/27

3- weld fwd cap as per dwg D3274 and Q81004

AR Aluminum Rod Batch:

M11742/M1A785 BB 12-01-30

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

BB

12/02/14

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

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QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

114

QC5- Inspect part completeness to step on W/O

0.00

114

QC

Memo

0.00

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00

116

QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00

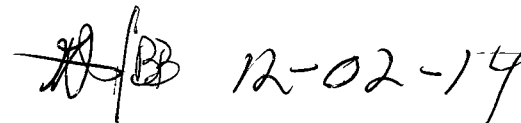
120

HandFinish

Memo

0.00

Hand Finishing



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Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

150

Skidtubes

0.00

150

Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291 119999

Sikaflex expire date: 12/02/14

Start: 5:00 Time: 12/02/14

Finish: 12-02-17 Time: 7:00

(Adhere for 12 hours)

12/02/14

12/02/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12/02/14	130	CHANGE Qc 3 - Qc 7 see w/o 74327 <i>HJ</i>	<i>BB</i>	12/02/14				

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Run Start ***NR1***

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Stop ***NR2***

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160 QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

DP 12-2-15

170 Skidtubes

0.00

170

Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

> S40 12-02-15

OK 12/02/16

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Dart Aerospace Ltd

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

12.02.21

210

QC10- Inspect visual per QSI004- ground welds

0.00

210

QC

Memo

0.00

Quality Control

*12.02.21**1x*

220

Pressure Wash per QSI005 4.3

0.00

220

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

1 M/V/20 Feb. 22/2012

W/O:		WORK ORDER CHANGES					
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1

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Required Date: 12/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

230

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

240

QC3- Inspect Part Finish

0.00

240

QC

Quality Control

Memo

0.00

250

HandFinishing

0.00

250

HandFinish

Hand Finishing

Memo

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/RSikaflex-291

Sikaflex expire date:

1 X 11/12/02/22

1 f 11/12/02/27

1 d 11/12/02/27

11/12/02/22

*11:00
3200F
11:30*

11/12/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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1

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

QC5- Inspect part completeness to step on W/O

0.00

260

QC

Quality Control

Memo

Inspect Nut Plate & Inserts

0.00

1 BR 12-2-23

270

HAND FINISHING RESOURCE #1

0.00

270

HandFinish

Hand Finishing

Memo

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/RSikaflex-291 11119568

Sikaflex expire date: 12/08

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: 101A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/RSikaflex-291 11119568

Sikaflex expire date: 12/08

1 4 11/12/23

Dart Aerospace Ltd

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Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00

280

QC

Memo

0.00

Quality Control

12-02-24 (1)

290

Identify as per dwg & Stock Location *ST*

0.00

290

Packaging

Memo

0.00

Packaging

PPP 74324 (12) SP 12-02-24

300

QC21- Final Inspection - Work Order Release

0.00

300

QC

Memo

0.00

Quality Control

12/2/24 ME 12-02-24

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 01/12/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B05.09.23 Revised per D206-642 Rev. JKJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
IPP Rev:F 08-06-02 add comment DD verified by:EC
IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190 *D2600-1-190* Extrusion Round 3" 206		Manufactured	No			110	Each	55.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				HALL				55					
					69622			55					
D3285-1 *D3285-1* Cap		Manufactured	No			110	Each	74.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				LG002				74					
					52511			27					
					52647			47					
D3282-041 *D3282-041* Float Web (206L/407)		Manufactured	No			150	Each	1.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				LG				1					
					70050			1					

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Parent Item Name: Replacement Skidtube

Start Date: 01/12/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 190 Each 548.0000 12 12

D2649

Cross Bolt Spacer

**

BE 12/02/10
878019 x12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	548	
65317	1	
68224	2	
68507	11	
71355	2	
72704	2	
72841	11	
73390	8	
73855	5	
73857	21	
73858	72	
73859	409	
73860	4	

D3275-1 Manufactured No 190 Each 324.0000 12 12

D3275-1

Crossbolt Spacer

**

BE 12/02/10

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	100	
74437	100	
LG002	224	
66930	106	
73393	118	

12

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Replacement Skidtube

Start Date: 01/12/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

250

Each

1,852.000

2

2

CR3212-4-03

Cherry Rivet

**

ul 12/02/23

Location

Loc Qty

Loc Code

FB

858

110139

0

114859

858

x2

ST331

994

110139

2

119017

992

D3415-041

Manufactured

No

250

Each

32.0000

1

1

D3415-041

Nut Plate

**

ul 12/02/23

Location

Loc Qty

Loc Code

ST053

32

67605

32

VI

CCR264SS3-3

Purchased

No

250

Each

1,095.000

2

2

CCR264SS3-3

Cherry Rivet

**

ul 12/02/23

Location

Loc Qty

Loc Code

ST331

1095

113973

2

117849

147

119017

946

y2

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Start Date: 01/12/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

250

Each

2,200.000

78

78

AI S4-1032-130

Insert

**

11/20/10 (x78) M 12/02/23

Location

Loc Qty

Loc Code

ST280

1984

119084

1984

ST281

216

117717

2

118237

12

118312

2

119632

200

D3536-15

Manufactured

No

270

Each

30.0000

1

1

D3536-15

Gasket

**

M 12/02/23

Location

Loc Qty

Loc Code

FP002

26

73318

26

FP011

4

71586

4

D3536-23

Manufactured

No

270

Each

38.0000

1

1

D3536-23

Gasket

**

M 12/02/23

Location

Loc Qty

Loc Code

FP

12

74510

12

FP002

25

73312

25

FP011

1

43406

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-01-11 12:53:19 PM

Page 5

Work Order ID: 77289

77289

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 01/12/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-35 Manufactured No 270 Each 40.0000 1 1
D3536-35 ** 12/02/27
Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	37	
73313	19	
<u>74511</u>	18	<u>VI</u>
FP012	3	
72882	3	

D3536-39 Manufactured No 270 Each 28.0000 1 1
D3536-39 ** 12/02/23
Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	26	
<u>73317</u>	26	<u>XI</u>
FP015	2	
69760	2	

D3535-15 Manufactured No 270 Each 28.0000 1 1
D3535-15 ** 12/02/23
Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	12	
74512	12	
FP007	16	
73006	3	
<u>73315</u>	13	<u>VI</u>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-01-11 12:53:19 PM

Page 6

Work Order ID: 77289

77289

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 01/12/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-35

Manufactured No

270 Each

27.0000 1 1

D3535-35

Wearshoe

**

HL 12/02/23

Location

Loc Qty

Loc Code

FP001

12

74509

12

XL

FP018

15

67598

1

70815

1

73311

13

D3535-39

Manufactured No

270 Each

33.0000 1 1

D3535-39

Wearshoe

**

HL 12/01/23

Location

Loc Qty

Loc Code

FP018

21

69759

1

73316

20

XL

FP021

12

74513

12

D3535-23

Manufactured No

270 Each

39.0000 1 1

D3535-23

Wearshoe

**

HL 12/02/23

Location

Loc Qty

Loc Code

FP001

13

74508

13

FP021

26

73314

26

XL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 77289

77289

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 01/12/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Manufactured No

270

Each

10.0000

1

1

D3537-3

Wearpad

**

1374500(x1) MU 12/02/23

Location

Loc Qty

Loc Code

FP002

10

73305

10

D3537-1 Manufactured No

270

Each

114.0000

9

9

D3537-1

Wearpad

**

1378592(x9) MU 12/02/23

Location

Loc Qty

Loc Code

FP002

107

74436

30

74597

5

74867

72

FP017

7

69817

5

70686

2

AN960C10L NAS1149C0332 Purchased No

270

Each

0.0000

80

80

*AN960C10I * X

washer

**

11120648(x80) MU 12/02/23

AN960C416 NAS1149C0463 Purchased No

270

Each

0.0000

1

1

AN960C416 X

washer

**

11117735(x1) MU 12/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 77289

77289

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 01/12/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270 Each

1,186.000 2 2

D3672-1

Phenolic Washer

**

41 12/02/23

Location

Loc Qty

Loc Code

FP

422

66821

422

x2

ST074

764

72229

264

76277

500

AN3C4A

Purchased No

270 Each

2,606.000 80 80

AN3C4A

BOLT

**

41 12/02/23

Location

Loc Qty

Loc Code

ST350

2606

M120423

x40

117313

2

M120799

v40

117688

5

117872

10

118112

16

118451

2

118838

954

119328

617

119749

1000

AN4C5A

Purchased No

270 Each

455.0000 1 1

AN4C5A

BOLT

**

41 12/02/23

Location

Loc Qty

Loc Code

FP-B

45

112243

45

x1

ST355

410

112243

310

119017

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 9

Work Order ID: 77289

77289

Parent Item: D206-642-541

D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 01/12/2011

Required Date: 12/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

213.0000

1

1

D2646

Aft Cap

**

ml 12/02/23

Location

Loc Qty

Loc Code

FP002

196

73294

2

73825

194

xl

FP004

8

68280

5

70945

1

71070

2

FP005

4

71038

4

FP006

5

62678

5

D3413-1

Manufactured No

270

Each

115.0000

1

1

D3413-1

Ring

**

B77940 (x1) ml 12/02/23

Location

Loc Qty

Loc Code

ST420

2

66387

1

70773

1

ST469

111

73822

56

75478

55

ST473

2

71041

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

SHOT COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 77289 H.C.J.
11/12/01

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

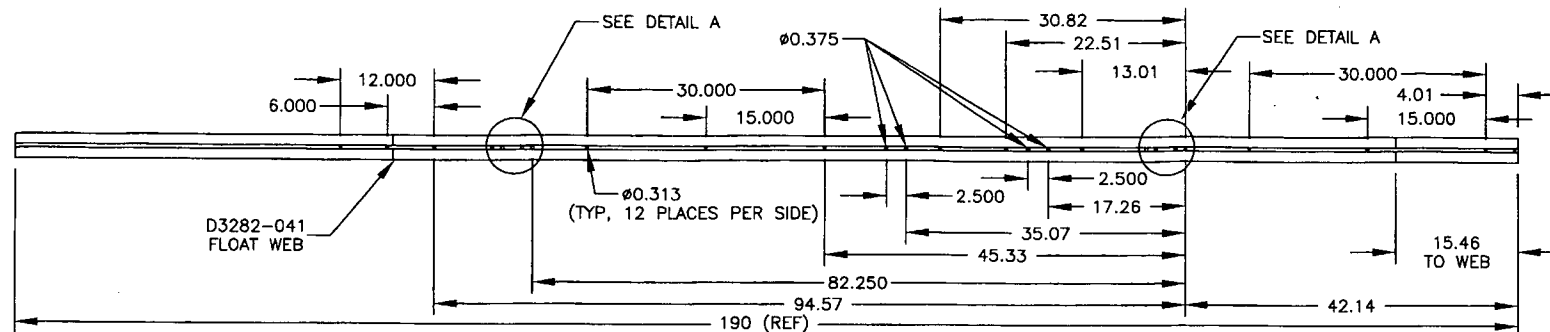
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

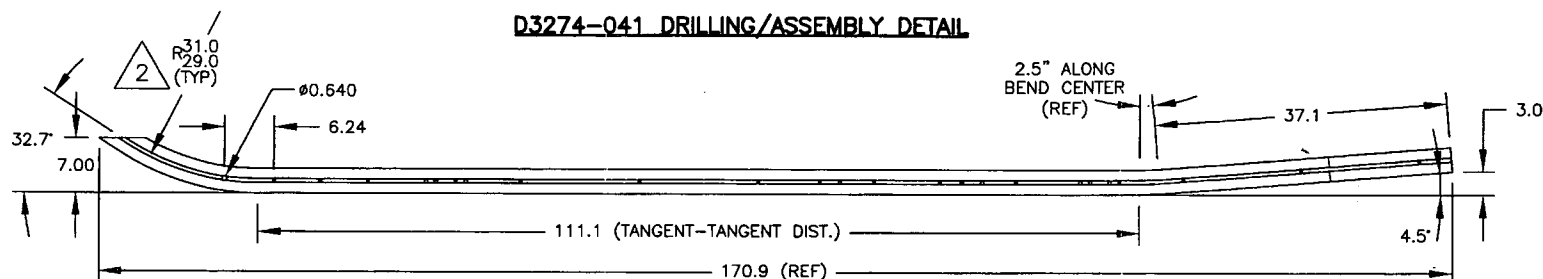
NOTE: Date & initial all entries

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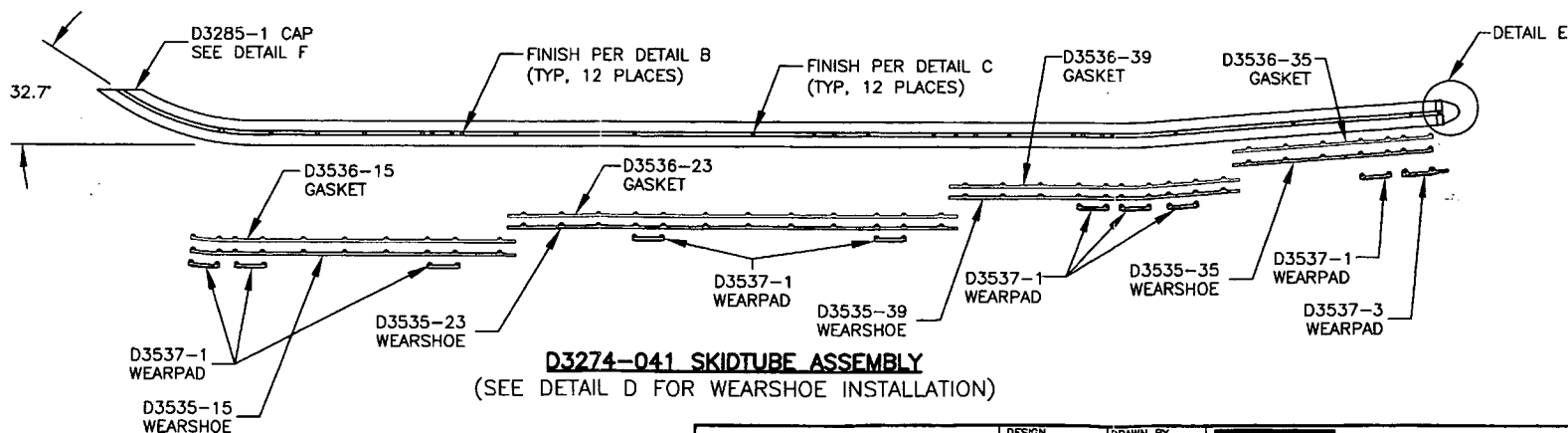
77289



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		SCALE 1:15	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

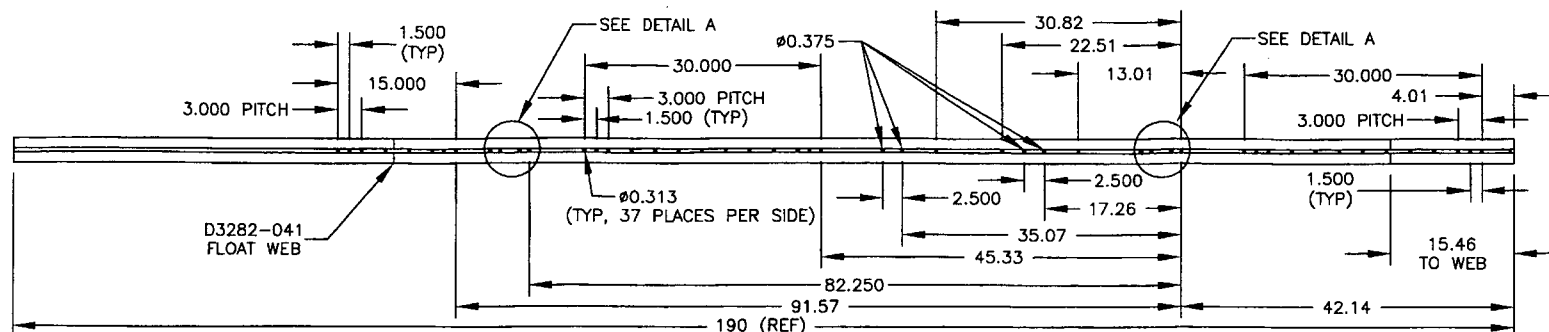
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

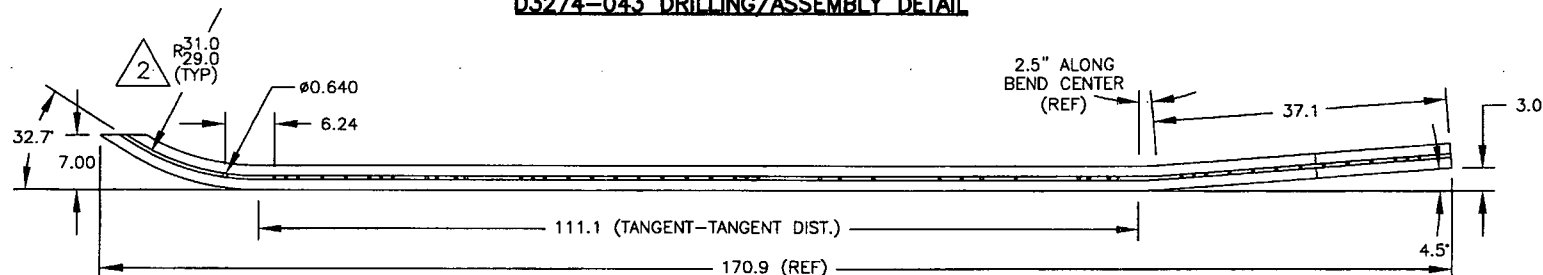
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

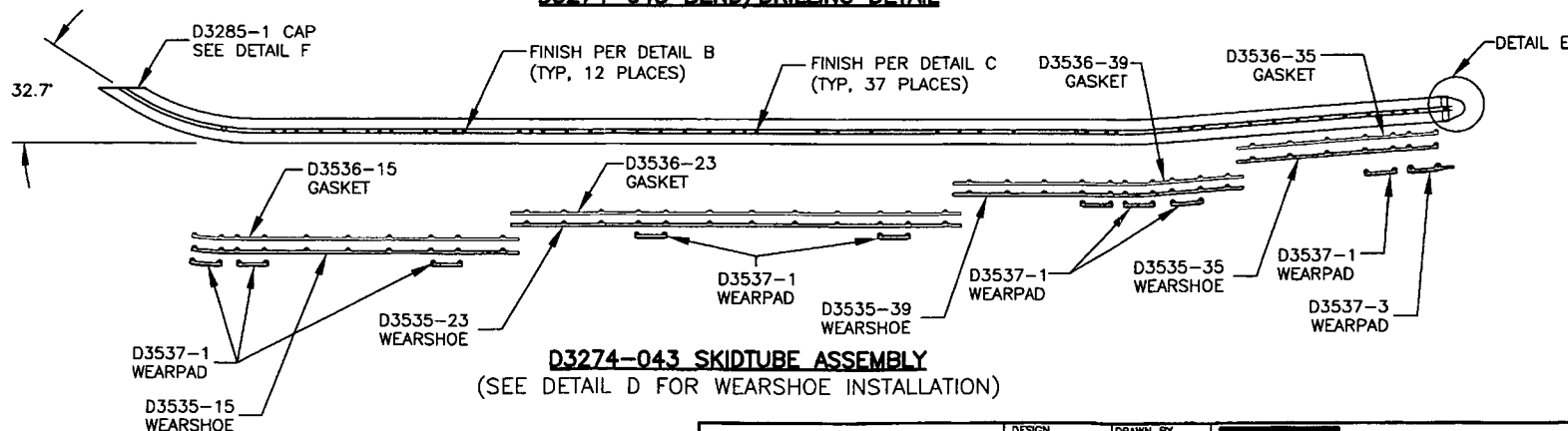
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		
		REV. D SHEET 3 OF 4 SCALE 1:15		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

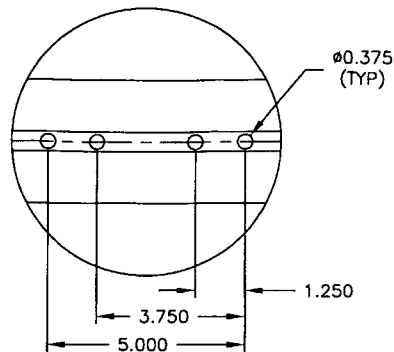
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

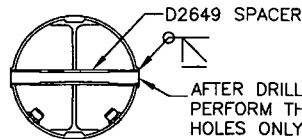
NOTE: Date & initial all entries

77289

DETAIL A: DRILL DETAIL

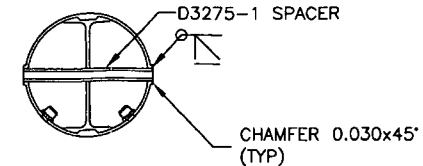


DETAIL B FOR 0.375 HOLES ONLY

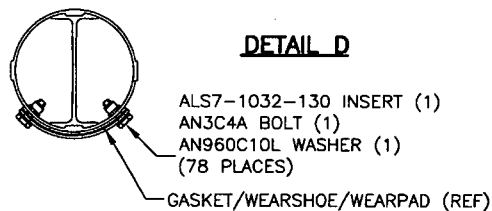


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY



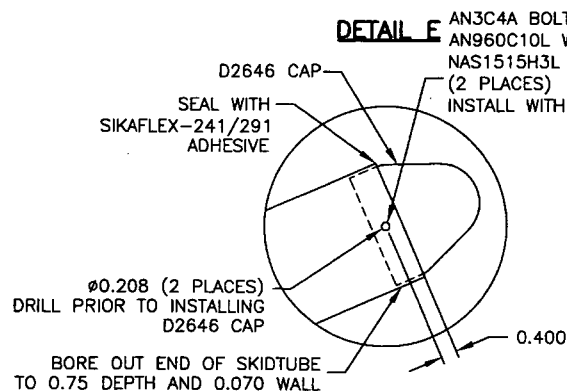
DETAIL D



- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



- AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

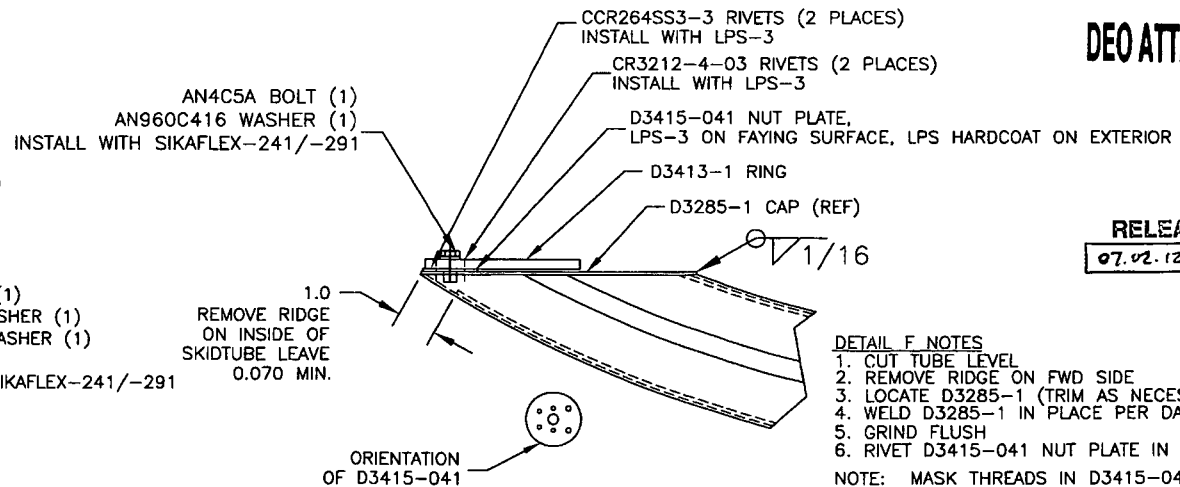
D2646 CAP

SEAL WITH
SIKAFLEX-241/291
ADHESIVE

0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL



CCR264SS3-3 RIVETS (2 PLACES)
INSTALL WITH LPS-3

CR3212-4-03 RIVETS (2 PLACES)
INSTALL WITH LPS-3

D3415-041 NUT PLATE,
LPS-3 ON FAYING SURFACE, LPS HARDCOAT ON EXTERIOR

D3413-1 RING

D3285-1 CAP (REF)

1/16

1.0
REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041

DEO ATTACHED

RELEASED
07.02.12

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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CHECKED H	APPROVED H	DRAWING NO. D3274		REV. D SHEET 4 OF 4	
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		SCALE 1:3	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

27289

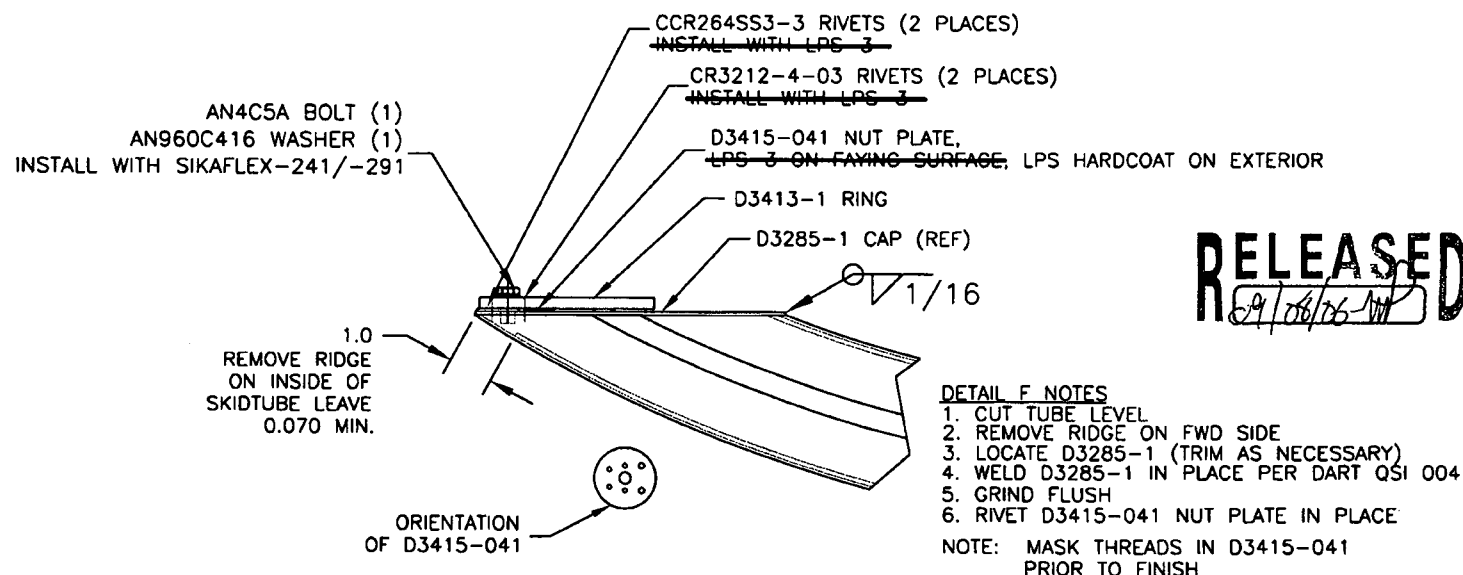
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries